

Date Wednesday, 15/08/2007 4:00:17 PM  
User Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
Job Number : 33936  
Estimate Number : 10192  
P.C. Number : *N/A* Part Number : D2171  
This Issue : 15/08/2007 S.O. No. : *N/A* Drawing Number : D2171 REV. D  
Prsht Rev. : *NC* Project Number : *N/A*  
First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : *D*  
Previous Run : 29085 Material : *N/A*  
Written By : Due Date : 31/08/2007 Qty: 100 Um: Each  
Checked & Approved By :  
Comment : Est: F 01.11.29 Reformat SM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *4371*  
Laser cut as per Dwg D2171 *CFI*  
Material: 304/316 SS 0.063" thick  
Material release note required

*C207108/16**100*

2.0 D2171F Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)  
CLAMP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage  
Ensure Material Release Note is attached

*7/9/13 SD**100X*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*(4.450" center to center) N/A**7/9/13**counted 100**PTC*

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1

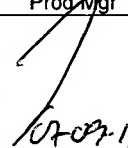
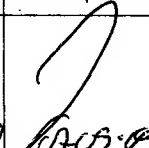


Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

*N/A*  
1- Debur  
2- Bend as per Dwg D2171  
3- Tumble

*SD 07/09/20**counted 100*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/18	4.0	Remove dimension. Dimension 4.150 is no good anyways. Perm. change				 07/09/18	 07/09/18

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/09/18  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:17 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 33936

Part Number: D2171

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counter*  
*50 07/09/24 (100)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*50 07/09/24 (100)*

8.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

*100*  
*207/09/25*

Job Completion



*50 07/09/25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

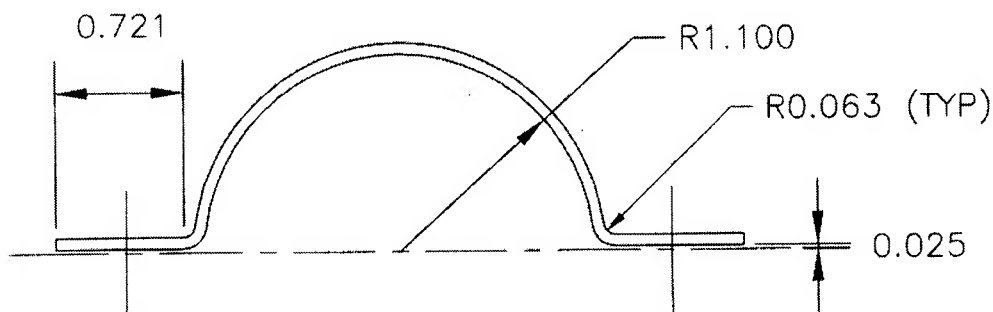
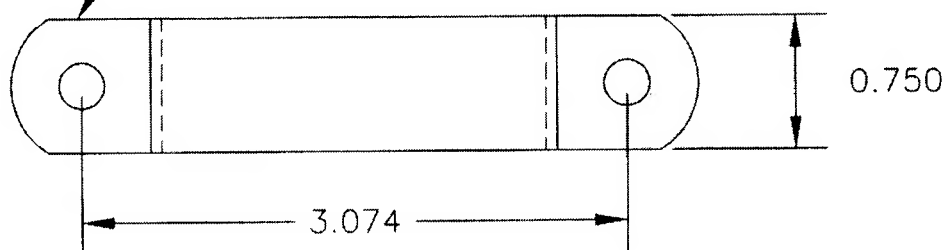
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY <del>MA</del>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

RELEASED  
99.03.11 KE

PUNCH ENDS PER SPEC  
CONTROL DRAWING D2727



W/O: 33936

MATERIAL: 304/316 SS 0.063 THICK  
FLAT LENGTH: 4.968 END-END  
4.158 HOLE-HOLE





180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7



# BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2007/09/12	0373801

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

	CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART	GFI-0299	J0167070	P000004371	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.		DESCRIPTION	
100	D2171 ✓ 7/9/17 59		CLAMP  CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RECEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECUPAR / RECEIVED BY

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LA BROsse AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	3	OUR JOB NO	J0167070	SHIPPING MEMO	0373801	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
---	100 PCS	P000004371	D2171	D	CLAMP	D
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SIGMA METALS / AK STEEL		H/N # 7361663 ATT'D		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE: 13 SEPTEMBER 2007

G.F.I. Q.C. REP.

*Signature*

288-0

**Sigma Metals Inc.****45 Jefryn Blvd.****Deer Park, NY 11729***A Small Woman Owned Business***(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426**

# Packing Slip

DATE INVOICE NO.

4/2/2007

43543

**BILL TO**

GFI INC.  
180 AVENUE LABROSSE  
POINT-CLAIRE  
QUE, CANADA  
H9R 1A1

**SHIP TO**

GFI INC.  
180 AVENUE LABROSSE  
POINT-CLAIRE  
QUE, CANADA  
H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0071346	Net 30	MEC	YELLOW	DEER PARK, NY	59881

ITEM	DESCRIPTION	QTY
SS T304	304 STAINLESS STEEL SHEET ANNEALED AMS 5513 .063" X 48" X 96" 168 LBS. MILL: AK STEEL LOT# 7361663 PRICED PER PC	2
	DOMESTIC CUSHPAK	1

**GFI INC.**

LE MATÉRIEL REÇU NE SERA ACCEPTÉ  
QU'APRÈS VÉRIFICATION DE DIMENSIONS,  
ÉPAISSEUR, POIDS ET CONDITIONS.

SIGNATURE

DATE

CERTIFICATE OF COMPLIANCE

THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT  
STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A  
FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT  
ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT  
DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL  
REQUIRED PROCEED CERTIFICATION AND CHEMICAL AND PHYSICAL TEST  
REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW.

THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED  
GREG SALADINO QC Gregory Saladino  
Quality Control Manager

ORDER CONFIRMATION - TEST REPORTS WITH SHIPMENT  
WE NOW ACCEPT VISA, MASTERCARD, AND AMERICAN EXPRESS





AK Steel Corporation  
Metallurgical Test Report  
Coshocton Works  
Coshocton, OH 43812

Page 1

Load No. 8304809  
SRN No. 8304809

MILL ORDER NO. 271940-0798  
PROCESSOR ORDER NO. 01009471

PART NO.  
00640

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
.0620 NOM 48.0000 X COIL

SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT
KD799032	1	7361663	0808293-02	16,080 LBS. 7,294 KG.
KD799033	1	7361663	0808293-02	18,010 LBS. 8,169 KG.
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT
2	2			34,090 LBS. 15,463 KG.

L=Ladle Analysis of Heat

P=Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
7361663	.016	1.30	.028	.001	.45	18.35	8.58	.35	.036	.41						

SHIPPING DATE: 02/07/2007

REMARKS:

THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A..  
NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA  
SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING  
ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.  
COILED PRODUCTS CONTAIN NO WELDS  
DEEP DRAW QUALITY

PRODUCT DESCRIPTION

CR SHT TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE \* AMS 5513 H \* ASTM A 240 -06 (UNS S30400) \* AMS 5511 H \* AMS 5516 N \*  
ASTM A 666 -03 \* MILS-5059 D-AMEND-3 \* UNS-S30403 9TH EDITION \* FMI-304L/304/302 ISSUE 7, 2/13/06 \* ASME SA-240 SECTION II PAR  
T A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 ED APPLY \* UNS-S30400/S30200

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front			
808293-02	T	T	A.S.T.M	60.0	83.7	36.1	B 78	B 76			

REVIEWED BY Q.C.

Date 2/8/07 by *cin*

\*\*\* CONTINUED ON NEXT PAGE \*\*\*





AK Steel Corporation  
Metallurgical Test Report  
Coshocton Works  
Coshocton, OH 43812

Page 2

Load No. 8304809  
SRN No. 8304809

MILL ORDER NO. 271940-0798  
PROCESSOR ORDER NO. 01009471

PART NO.  
00640

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
.0620 NOM 48.0000 X COIL

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	GRAIN SIZE ASTM E112	BEND 180 IT					
308293-02	T		A.S.T.M	PASS	8.00	PASS					
308293-02	F		A.S.T.M	PASS	8.00	PASS					

SIGMA METALS INC.

THESE TEST REPORTS APPLY TO:

6ET  
P.O. 0071346  
S/O 59881  
PCS. 2 FTG  
NET 168# DATE 4.2.07

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT  
AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MMWCKC049 5/99

THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK  
Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A  
THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE

SIGNED

*Eric Raymond*  
APPLICATION ENGINEER

DATE 02/08/2007 TIME 05:27 AM